Work Order Thursday, August I	· <b>ID 73095</b> 25, 2011 1:27:46 PM										Page 1
Revision ID:	03302-3 oubler		Accept					Setup	Start Stop		
Start Date: 8/ Required Date: 9/ Reference:	725/2011 Start Qty: 6.00 Req'd Qty: 6.00			Cust Item I Customer:	D:					1	
Approvals: I	Process Plan: _ MK	Date: 1-08/	25 Tooling:	Da	ite:		!	Run	Start		
. (	QC:	Date:	SPC (Y/N):		ite:				Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr										
D3302	Rev B2										
100 Waterjet	FLOW WATER JET		0.00				B(	1-8-3	31		
FLOW CNC Waterjet	<b>Memo</b> 1-Cut as pe Deburr if n	er Dwg D3302 Dwg F ecessary	0.00 Rev:_ <b>B2</b> _□Prog Rev:_	<u>82</u> <sub>=2</sub> -						(7)	
	QC2- Inspect parts off r	machine FAI/FAIB	0.00				10 L	, g -	5 i		
QC Quality Control	Мето		0.00				- KI	1-8-	<u> </u>		,
120	QC8- Inspect parts - sec	cond check	0.00	o E(3,			(x7)	·)			
QC Quality Control	Memo		0.00	~ O(3)				7			

# **Dart Aerospace Ltd**

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W/O:			WO	RK ORDER CHANG	ES						
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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					·						
Part No	•	PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQ	<b>A</b> :	Date: _			
	R	esolution:	Disposition	:	QA: N/C Closed: Date:						
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE (NCF	R)					
DATE	STEP	Description of NC		ion B	Verifi	cation	Approval	Approval			
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector		
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Work Order ID 7309	Work	Order	ID	73095
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Thursday, August 25, 2011 1:27:46 PM



Page 2

Item ID:

D3302-3

Accept

Setup Start

Stop

Stop

**Revision ID:** 

Item Name:

Start Date:

Doubler

8/25/2011

Start Qty: 6.00

Req'd Qty: 6.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

Date:

Start Run

Qty



Required Date: 9/5/2011

QC:

Date: \_\_\_\_\_

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool ID

Tool # Plan

Code

Reject Accept

6,43

Qty

Reject Number

Insp. Stamp

Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

0.00 Deburr break all unmarked sharp edges 0.005 to 0.010

140

Brake NC

Brake NC

NC BRAKE

Memo

Memo

Form as per Dwg D3302

0.00

Sbulogla

150

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

## **Dart Aerospace Ltd**

W/O:				WORK ORDER	VORK ORDER CHANGES							
DATE	STEP		PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
					-							
Part No	:		PAR #:	Fault Category:	NCR: Y	es No <b>D</b> O	A:	Date: _				
	R	esolution:		Disposition:	QA: N/C	Closed: _		Date: _				

	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B		Verification	Approval	Approval		
STEP	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto	
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	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial Chief Eng	STEP  Description of NC Section A  Initial Chief Eng Corrective Action Section B  Action Description Chief Eng Chief Eng Action Description Chief Eng Chief Eng Action Description Chief Eng Chief Eng Action Description Chief Eng Action Description Chief Eng Action Description Chief Eng	STEP Description of NC Section A Initial Chief Eng Chief	STEP  Description of NC Section A  Initial Chief Eng Chi	STEP  Description of NC Section A  Initial Chief Eng  Chief Eng		

Work Ord Thursday, Augu											Page 3
Item ID: Revision ID: Item Name:	D3302-3  Doubler			Accept				Setup	Start Stop		
Start Date: Required Date: Reference:	8/25/2011	Start Qty: 6.00 Req'd Qty: 6.00	100   10   10   10   10   10   10   1		Cust Item II Customer:	D:			·		815 HE 1161   1611
Approvals:	Process Pla	an:	Date:			te:		Run	Start Stop		
Sequence ID/ Work Center II  160  HandFinish Hand Finishing	D	Operation Description Chemical Conversion Co	at per QSI005 4.1	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	Accep Qty	ot Ri	-	Reject Number	Insp. Stamp

170

Quality Control

QC3- Inspect Part Finish -

0.00

Memo

0.00

7 \$ 14 11/08/12

180

Packaging Packaging

Memo

Identify as per dwg & Stock Location: 51 143

0.00

11-09-136

Dart /	Aeros	pace l	Ltd
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W/O:			W	ORK ORDER CHANG	FS					
DATE	STEP	PRO	OCEDURE CHA		Ву	C	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	_ NCR: Ye	s No	DQA	٨:	Date:			
	R	esolution:	ution: Disposition: (						Date: _	
NCR:		,	WORK ORD	DER NON-CONFORMA	NCE (NO	CR)				
DATE	STEP	Description of NC	Description of NC Corrective Action				Verific	ation	Approval	Approval
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# **Picklist Print**

Thursday, August 25, 2011 1:27:43 PM

Work Order ID: 73095

D3302-3

Parent Item Name: Doubler



Start Date: 8/25/2011

Required Date: 9/5/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

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Ca	mı	ne	nte	٠

Parent Item:

□A□04.09,02□New issue□KJ/JLM□

□B□06.05.02 □ Water jet

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No		100	sf	283.1256		6.272211	44.		
6061-T6 063 Sheet									KB (1-8	-31		

6061-T6 .063 Sheet

<b>Location</b>	Loc Qty	Loc Code	
MAT021	283.1255684	4	
116308	26.9755684		
117285	111.15		
118580	145		118260

Dart Ae	rospace	e Ltd								
W/O:			W	ORK ORDER CHANGES						
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No:							A:	Date:		
	R	esolution:	Disposit	Disposition: QA: N/C Closed: Date:						
NCR:		V	VORK OR	DER NON-CONFORMANO	CE (NCF	<b>?</b> )				
		Description of NC		Corrective Action Section B		Verifi	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector	
-										
		.8.7			·					

DART AEROSPACE LTD	Work Order: 7	3090
Description: Doubler	Part Number:	D3302-3
Inspection Dwg: D3302 Rev: B2		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual · Dimension	Accept	Reject	Method of Inspection	Comments
14.452	+/-0.010	14.452	9		7 BOI	
12.75	+/-0.030	13.75	ъ		7	
0.851	+/-0.010	-855	X		V BOZ	
0.851	+/-0.010	.854	2		V	
8.952	+/-0.010	8.959	7		P ROWSOZ	
R0.12	+/-0.030	(1)	×		R.G.	
7.250	+/-0.010	7.750	3		V	
						,

Measured by:	B	Audited by:	Prototype Approval:	N/A				
Date:	11-8-31	Date: 11/08/31	Date:	N/A				

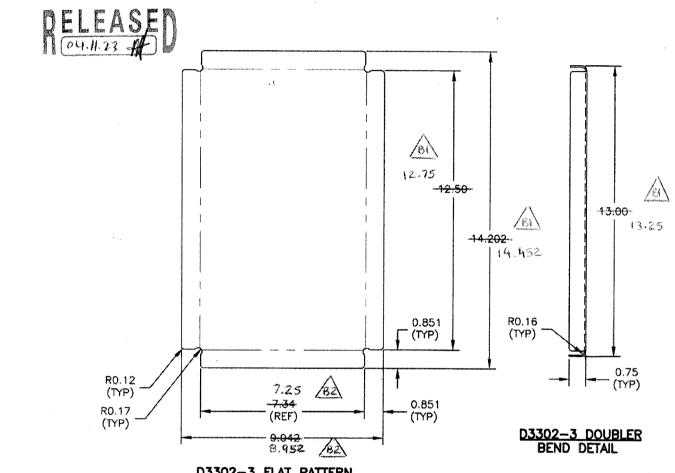
Rev	Date	Change	Revised by	Approved
Α	04.09.03	New Issue	KJ/JLM	
В	06.03.09	Dwg Rev update; Dimensions revised to revision B2	KJ/JLM	
С	07.01.16	Dimensions revised	KJ/JLM ,	1
D	07.01.29	Dimensions revised	KJ/JLM CK	all

Dart Aerospace Li	_LU
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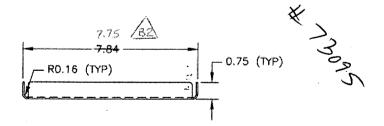
W/O: WO				ORK ORDER CHANGE	S				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				**************************************				<u> </u>	
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositio	n:	QA: N/C CI	osed:		Date:	
NCR:		\	WORK ORD	ER NON-CONFORMAN	NCE (NCF	<b>R</b> )			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC inspector
	-								
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DESIGN PA	DRAWN BY		OSPACE LTD, ONTARIO, CANADA
CHECKED III	APPROVED	DRAWING NO.	REV. B
#	4	D3302	SHEET 2 OF 4
DATE		TITLE	SCALE
04.11.18		DOUBLER	1:4



#### D3302-3 FLAT PATTERN



#### D3302-3 NOTES:

- MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

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### **Dart Aerospace Ltd**

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W/O: WORK ORDER CHANGES									
DATE STEP		PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	_ Fault Cate	egory:	NCR: Yes	No <b>DQ</b>	<b>A</b> :	Date: _	·
		esolution:	Disposition	on:	_ QA: N/C Closed:			Date:	
NCR:		W	ORK ORE	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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